

# Work Order ID 52380

Tuesday, September 22, 2009 11:48:57 AM



Page 1

Item ID:	D3524-1 <b>BK</b>	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	Lower Plate					
Start Date:	9/23/2009	Start Qty: 6.00		Cust Item ID:		
Required Date:	10/9/2009	Req'd Qty: 6.00		Customer:		
Reference:						

Approvals:	Process Plan: <u><i>RL mk</i></u>	Date: <u>09-9-22</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3524	Rev A								

100		BAND SAW	0.00	<i>H.A. 09/08/01</i>	<u>6</u>	<u>0</u>		
	Bandsaw	Memo	0.00					
	Jeaspa Bandsaw	Cut Blanks 2.750" Long						

110		HAAS CNC VERTICAL MACHINING #1	0.00	<i>H.A. 09/10/07</i>	<u>6</u>	<u>0</u>		
	HAAS 1	Memo	0.00					
	HAAS CNC vertical machine #1	1- Mill as per Folio FA699 Rev: <u>A</u> & Dwg D3524 Rev: <u>A</u> <input type="checkbox"/> 2-Deburr per dwg D3443						

120		QC2- Inspect parts off machine FAI/FAIB	0.00	<i>H.A. 09/10/07</i>	<u>6</u>	<u>0</u>		
	QC	Memo	0.00					
	Quality Control							

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Item ID: D3524-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Lower Plate

Start Date: 9/23/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

OK 09/10/07

6

0

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

OK 09-10-8

6

Hand Finishing

150

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

OK 09-10-9

6

Powder Coating

START TIME: 8:35

OVEN TEMPERATURE:

3:00 FINISH TIME:

9:05

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Page 3

Item ID: D3524-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Lower Plate

Start Date: 9/23/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00	<i>HL</i>	<i>09/10/09</i>		<i>(X6)</i>	<i>6</i>		
170  Packaging Packaging	Identify as per dwg & Stock Location: <i>105</i>  Memo	0.00 0.00					<i>Rec'd 10/5</i>	<i>(6)</i>	
180  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00					<i>09/10/13</i>	<i>MF</i>	<i>09-10-09</i>

# Picklist Print

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Page 1

Work Order ID: 52380



Parent Item: D3524-1RevA



Parent Item Name: Lower Plate

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.375X03.00 0		Purchased	No			110	f	24.4800	1.4223			



6061T6 BAR .375 X 3.00

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

24.48

17887

16.65

18237

7.83

1.400

Y.A  
09/10/01

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 52380
<b>Description:</b> LOWER PLATE		<b>Part Number:</b> D3524-1
<b>Inspection Dwg:</b> D3524	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.47	+/- .030	0.470	✓			
2.00	+/- .030	2.004	✓			
1.063	+/- .010	1.065	✓			
1.250	+/- .010	1.251	✓			
1.000	+/- .010	1.001	✓			
1.625	+/- .010	1.624	✓			
0.44	+/- .030	0.440	✓			
Ø 0.144	+0.004/-0.001	Ø 0.147	✓			
C'SINK Ø.250x100°	+/- .010	Ø 0.252x100°	✓			
0.250	+/- .010	0.247	✓			
Ø 0.750	+0.005/-0.000	0.7525	✓			
2.50	+/- .030	2.504	✓			
0.130	+0.000/-0.010	0.130	✓			
0.20 x45°	+/- .030	0.203x45°	✓			
R0.375	+0.005/-0.000	R0.375	✓			
0.711 (ref)	<del>0.000</del> +/- .010	0.712	✓			

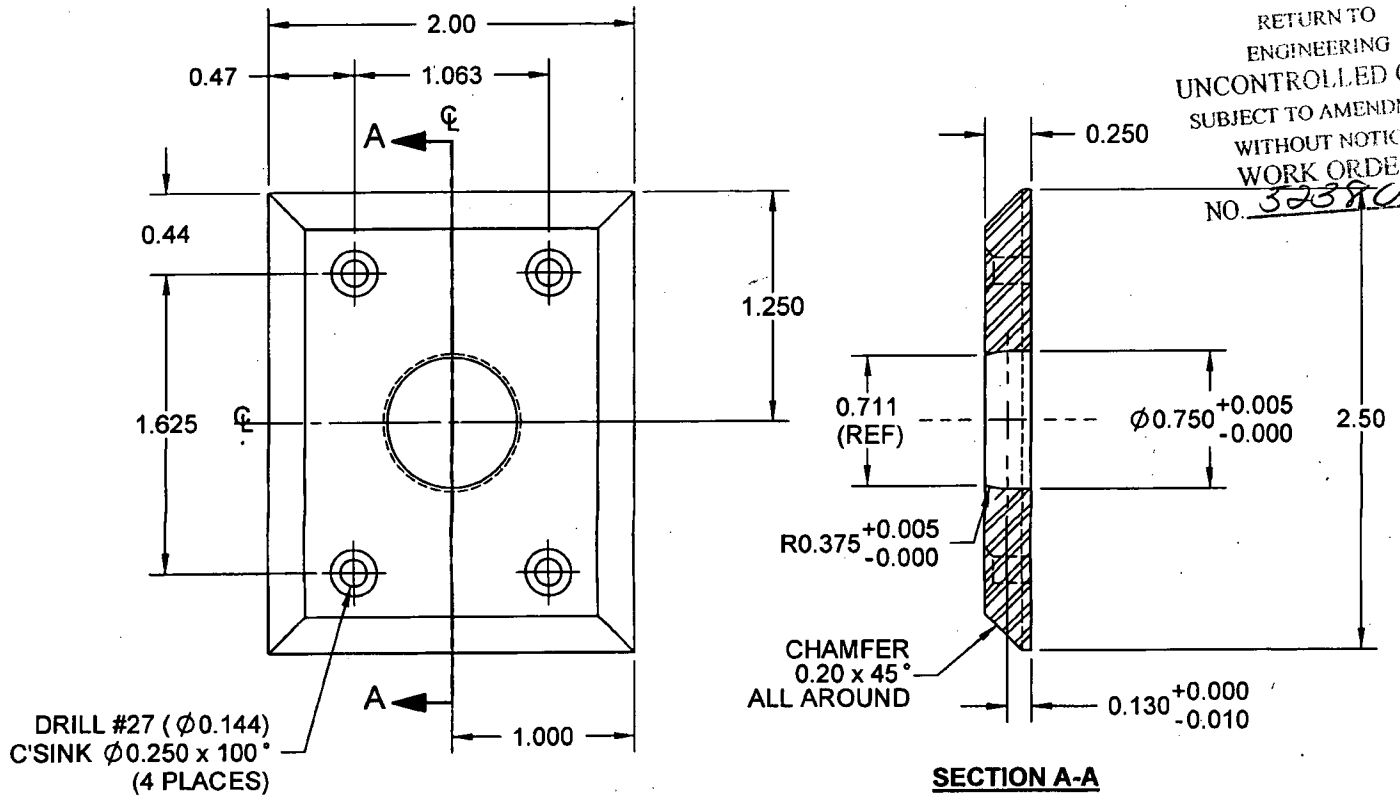
<b>Measured by:</b> J.A	<b>Audited by:</b> <i>[Signature]</i>	<b>Prototype Approval:</b> N/A
<b>Date:</b> 09/10/07	<b>Date:</b> 09/10/07	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

**DART**

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED H	DRAWING NO. D3524	REV. A SHEET 1 OF 3
DATE 07.07.24	TITLE UPPER AND LOWER PLATE		SCALE 1:1
REV A	DATE 07.07.24	DESCRIPTION NEW ISSUE	

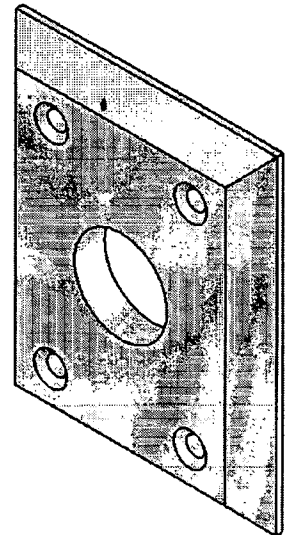
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WITHOUT NOTICE  
WORK ORDER  
NO. 32380

**D3524-1 LOWER PLATE**

RELEASED  
07.08.03

**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T651/T6510/T6511/T62 BAR PER QQ-A-225/8 OR AMS 4115/4116/4117/4128 OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART SYMMETRIC ABOUT  $\phi$



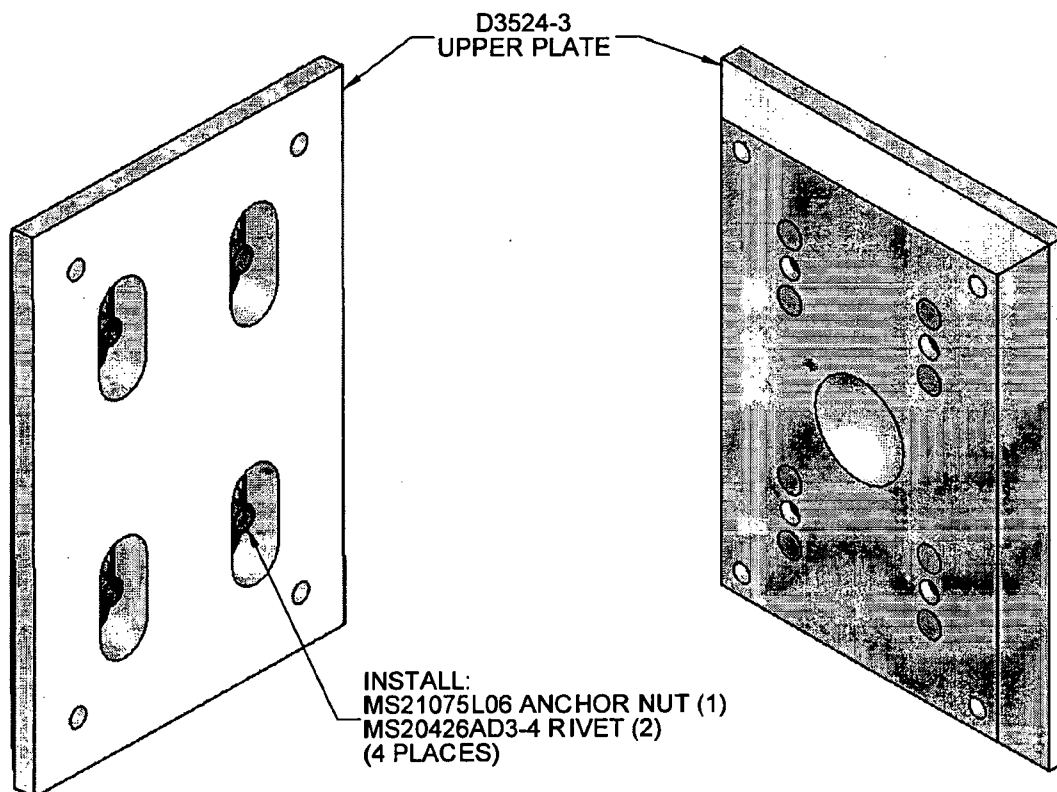
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52350

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3524	REV. A SHEET 2 OF 3
DATE 07.07.24		TITLE UPPER AND LOWER PLATE	SCALE 1:1



**D3524-041 UPPER PLATE ASSEMBLY**

**RELEASED**  
07.08.03 [Signature]

**PARTS LIST:**

QTY	PIN	DESCRIPTION
X	D3524-041	UPPER PLATE ASSEMBLY
1	D3524-3	UPPER PLATE
4	MS21075L06	ANCHOR NUT
8	MS20426AD3-4	RIVET

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**DART**

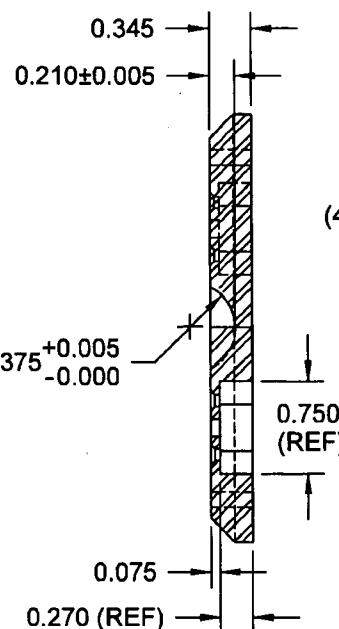
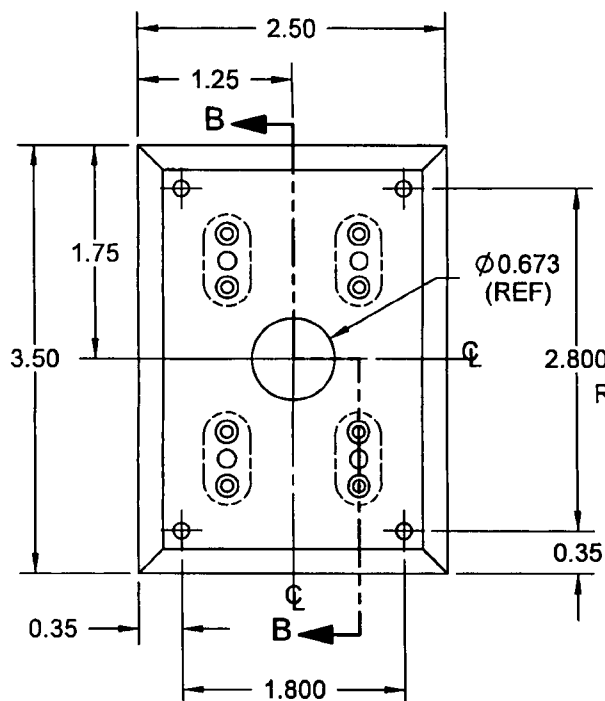
DESIGN	C.B.	DRAWN BY	C.B.	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED	CE	APPROVED	[Signature]	DRAWING NO. D3524
DATE	07.07.24	TITLE	UPPER AND LOWER PLATE	REV. A SHEET 3 OF 3
		SCALE	2:3	

52350

DRILL #40 ( $\phi 0.098$ )  
C'SINK  $\phi 0.185 \times 100^\circ$  OTHER SIDE  
(8 PLACES)

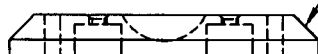
DRILL #27  
( $\phi 0.144$ )  
(4 PLACES)

DRILL #30  
( $\phi 0.129$ )  
(4 PLACES)

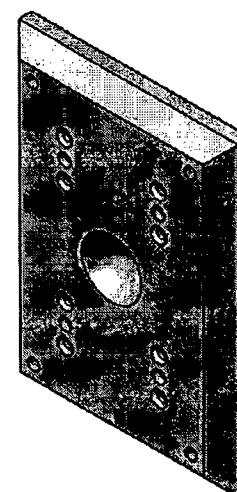


**SECTION B-B**

CHAMFER  
0.20 x 45°  
ALL AROUND



**D3524-3 UPPER PLATE**



**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T651/T6510/T6511/T62 BAR PER QQ-A-225/8 OR AMS 4115/4116/4117/4128 OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
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- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
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- 6) PART SYMMETRIC ABOUT  $\phi$

**RELEASED**

07.08.23

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